



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-3

Job Sheet 170932



Part No: D3296-3

Job Qty: 4 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 2/7/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:E Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/6/18	0.00	0.00	Start Up Waterjet		SC 18/02/06
100	Waterjet	4 pcs		2/6/18	0.04	0.32	Waterjet1		SC 18/02/06
120	QC	4 pcs		2/6/18	0.00	0.00	QC8		38
130	Small Fab	4 pcs		2/6/18	0.00	0.00	Small Fab-3		9-88
140	HandFinish	4 pcs		2/7/18	0.00	0.21	HandFinish1		2018/02/12 JSC
150	QC	4 pcs		2/7/18	0.00	0.00	QC7-2		SC
160	Packaging	4 pcs		2/7/18	0.00	0.00	Packaging3		DAS FEB 13 2018
170	QC21-SA	4 Ea		2/7/18	0.00	0.00	QC21		6 DAS FEB 14 2018 9-89 21 9-88

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	2.6128 sf (.6532 ea)	90-Start up Operation	
M135389				

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	3	185	0
3				

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.030inches ± 0.030	5.060 5.000	5,020	
2	Door Panel	0.060inches ± 0.010	0.070 0.050	0,060	
3	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128	0,128	
4	Door Panel	17.000inches ± 0.030	17.030 16.970	17,00	
5	Door Panel	16.400inches ± 0.005	16.405 16.395	16,400	
6	Door Panel	0.300inches ± 0.010	0.310 0.290	0,304	
7	Door Panel	0.300inches ± 0.010	0.310 0.290	0,303	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ D	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross-tube ☐ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐
 S040492 Door Panel PART NO: D3296-3 Original Serial #: S040492 Revision: Operation: Start up Operation Change No:		02/08/18 Job No: 170932	
MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			

Root Cause			
Environment	☐	No re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

8	Door Panel	1.000inches + 0.030 - 0.010	1.030 0.990	1.005
9	Door Panel	0.063inches ± 0.010	0.073 0.053	0.065

Plex 1/24/18 10:22 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					